

Work Order ID 102739

102739

Page 1

June-12-13 9:13:08 AM

Item ID: D3489-3-200 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: PIP PIN
 Start Date: 6/11/13 Start Qty: 10.00 *10* Cust Item ID:
 Required Date: 6/11/13 Req'd Qty: 10.00 *10* Customer:
 Reference:

Approvals: Process Plan: W Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3489	Rev A								
100	PURCHASING	0.00							
100									
Purchasing	Memo	0.00							
Purchasing	Issue P/O: 20160 P/N: 806206 Possible Supplier: Jergens								
110	Receive & Inspect for Damage & Mat'l Certs	0.00							
110									
Packaging	Memo	0.00							
Packaging	Ensure material certification is attached								
120	QC6- Inspect dimensions to drawing	0.00							
120									
QC	Memo	0.00							
Quality Control									

CX 13/06/13 (10)

13/6/20 (10)

10

13.6 20

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
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Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Work Order ID 102739

102739

Page 2

June-12-13 9:13:09 AM

Item ID: D3489-3-200

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: PIP PIN

Start Date: 6/11/13 Start Qty: 10.00

10

Cust Item ID:

Required Date: 6/11/13 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location

GA

0.00

130

Packaging

Memo

0.00

Packaging

10X

SP
13-06-20

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MCJ 13-06-21

13-06-20

DQA: _____ Date: _____



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QA Closed: _____ Date: _____

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DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3489	REV. A SHEET 1 OF 1
DATE 06.01.04		TITLE PIP PIN	SCALE NTS
A	06.01.04	NEW ISSUE	

SPECIFICATION CONTROL DRAWING

1) SPECIFICATION: D3489-X-YYY PIP PIN

WHERE 'X' IS THE NOMINAL SIZE IN 1/16THS OF AN INCH
AND 'YYY' IS THE GRIP LENGTH IN TENTHS OF INCHES

FOR EXAMPLE, D3489-3-050 IS 3/16" NOMINAL O.D. WITH 0.50" GRIP

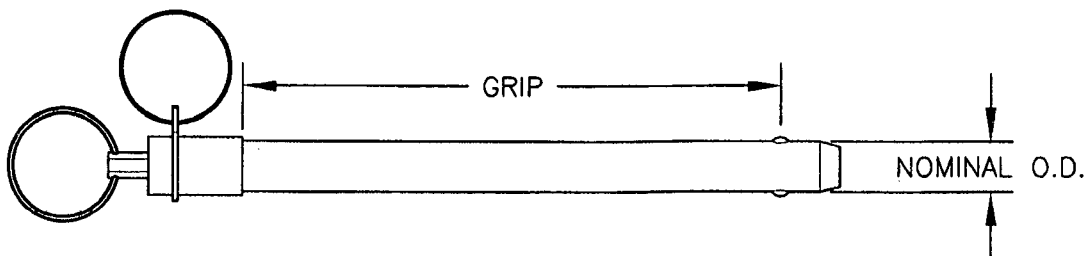
2) ACCEPTABLE SUPPLIERS / PART NUMBERS TO PURCHASE

DART P/N	Nominal O.D.	GRIP	Possible Suppliers	
			JERGENS	REID
D3489-3-050	3/16"	0.50	806200	DARS-000D
D3489-3-075	3/16"	0.75	806201	-
D3489-3-100	3/16"	1.00	806202	DARS-001
D3489-3-125	3/16"	1.25	806203	-
D3489-3-150	3/16"	1.50	806204	-
D3489-3-175	3/16"	1.75	806205	-
D3489-3-200	3/16"	2.00	806206	DARS-004
D3489-3-250	3/16"	2.50	806208	DARS-005
D3489-3-300	3/16"	3.00	806209	-
D3489-4-050	1/4"	0.50	806216	DARS-009
D3489-4-075	1/4"	0.75	806217	-
D3489-4-100	1/4"	1.00	806218	-
D3489-4-125	1/4"	1.25	806219	-
D3489-4-150	1/4"	1.50	806220	DARS-020
D3489-4-175	1/4"	1.75	806221	-
D3489-4-200	1/4"	2.00	806222	DARS-030
D3489-4-250	1/4"	2.50	806224	DARS-035
D3489-4-300	1/4"	3.00	806225	DARS-040
D3489-4-400	1/4"	4.00	808227	DARS-050

3) DESCRIPTION: DOUBLE ACTING, STAINLESS STEEL, QUICK-RELEASE BALL LOCK PINS WITH RING HANDLE

4) MATERIAL: STAINLESS STEEL. MIN. PULL OUT STRENGTH = 200LBS (3/16" PINS) OR 230LBS (1/4" PINS). MIN. DOUBLE SHEAR = 5150LBS (3/16" PINS) OR 9200LBS (1/4" PINS).

5) ALL DIMENSIONS ARE IN INCHES



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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO20160

Purchase Order Date 6/13/2013

PO Print Date 6/17/2013

Page Number 1 of 5

Order From :

VC-HAS001

HASKINS INDUSTRIAL
5-52 ANTARES DRIVE
NEPEAN, ON K2E 7Z1
CA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

PAID
6/13/2013

Contact Name

Vendor Phone 613 723 8800

Ship To Contact

Ship To Phone

Ship Via: Dicom

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms Net 30

Currency CAD

FOB Destination-Collect

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	List Price	Disc %	Discounted Unit Price	Extended Price
	Line Comments		Promise Date						
	Delivery Comments								
1	806206	PIP PIN	6/19/2013		10.00				\$228.20
			Yes		Each				
	AS PER DWG D3489 REV. A B102739		6/19/2013						
Line Total:									\$228.20
2	D3672-3P	WASHER	6/19/2013		500.00				\$161.45
			Yes		Each				
	AS PER DWG D3672 REV. C B102961		6/19/2013						
Line Total:									\$161.45
3	71500-30	110-0500-402 1/2 4FL DEBOER END-MILL	6/17/2013		3.00				\$132.12
			Yes		Each				
			6/17/2013						

Note:

6/17/2013

HASKINS INDUSTRIAL INC.
5-52 ANTARES DRIVE

** PACKING SLIP **

Order # 1249730.0

Order Date 06/17/13

NEPEAN, ONTARIO K2E 7Z1
TEL (613) 723-8800 FAX (613) 723-8806

Page 1 of

Sold To: DART AEROSPACE LTD.
1270 ABERDEEN STREET
HAWKESBURY
ON
K6A 1K7

Ship To: DART AEROSPACE LTD.
1270 ABERDEEN STREET
HAWKESBURY
ON
K6A 1K7

* Reprint

Cust Phone # Warehouse F.O.B. Taken By
OTTAWA DEST Sylvie 613-723-8

Cust # Customer P/O # Required Orig Order Slsm Ship Via Terms
05168 20160 06/18/13 1249730.00 PL DICOM NET 30

Ln# Bin # Order UM Ship B/O Product Description

1		3 EA	0	3	DB1X1	110-0500-402 1/2	4FL BN CARB EM
2		50 C	0	50	SP1X100	HC-27 5/16-18X1	C/S
3		50 C	0	50	SP1X100	HX-224 1/4-20X1"	FLAT HEAD C/S
4		1 EA	1		KEO1X1 1152723 ✓	E05K SCLP18	CARBIDE BORING BAR
5 *		4 EA	3	1	SO1X1 ✓	604-087 #26065	CLAMP 6/PKG
6 *		1 EA	1		SO1X1 ✓	136-757 1/4 RAD X	3/4SHK CUTTER
7 *		1 EA	1		SO1X1	136-750 1/16" RAD	CUTTER
8 *		2 EA	0	2	HAR1X1	21050-C3 .050R 4FL	ALTIN CUTTER
FREIGHT TO BE ADDED FROM HARVEY TOOLS							
9 *		1 EA	1		SO1X1 ✓	122-105 1/2 45DEG	DOVETAIL CUTTER
10		20 EA	20		KEO1X1 1158624 ✓	CNMG432K KC935	INSERT
11	030220	10 EA	10		JG-806206 ✓	3/16 DBL ACTION RING HANDLE	8062
12	CAB810	500 EA	500		MMS-D3672-3 ✓	.500 X .267 X .031 +/- .002 WASHER, PHE	

PLEASE NOTE:

1. NO RETURNS WITHOUT PRIOR AUTHORIZATION
2. ALL SHORTAGE CLAIMS MUST BE WITHIN 10 DAYS
3. BO CODE: BO = QTY NOT SHIPPED IS BACK-ORDERED
CL= QTY NOT SHIPPED WAS CANCELLED
SC= ITEM CONSIDERED COMPLETE - NO B/O CREATED

FILL PACK DATE 6/18/13
Printed on 2013-06-18 at 9:15